

23/05

Dart Aerospace Ltd.

Date: Friday, 16/05/2008 7:45:50 AM  
 User: Linda Lacelle

## Process Sheet

Split w/o  
 SB 08/05/21

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE  
 Job Number : 39312  
 Estimate Number : 10437  
 P.O. Number :  
 This Issue : 16/05/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D33191  
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3319 REV. B  
 Previous Run : 38646 Material : B  
 Due Date : 23/05/2008 Qty: 15  
 Written By :  
 Checked & Approved By :  
 Comment : Est: B 05.10.14 Added step 9, dwg rev B KJ/EC  
 Est Rev:C Now on Waterjet 06-10-26 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S18GA 1010/1025/A21/6aA SHEET .048



Comment: Qty.: 0.6594 sf(s)/Unit Total : 7.9128 sf(s)

1010/1025/A21/6aA SHEET .048

Batch: 106603 B 8-5-20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: B B 8-5-20

Prog Rev: B

2-Deburr if necessary B 8-5-20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

n/a Done at set sen  
 #2.2 & 08/05/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Drawing Name: WEARPLATE

Job Number: 39312

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

2- Form flat on press using DT8776 block

08/05/21

(15)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/05/21 (15)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: \_\_\_\_\_

Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod

M106762

08-05-26

(15X)

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/05/26 (15)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/26 (15)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00 PM  
320°F  
1:30 PM

M-H 08/05/26

(15X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-05-26 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Drawing Name: WEARPLATE

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Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



15X

Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 496

8/5/06

SP

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08.05.27



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

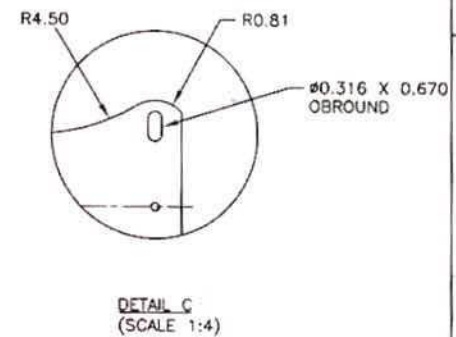
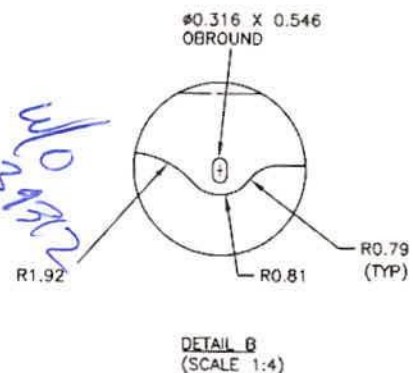
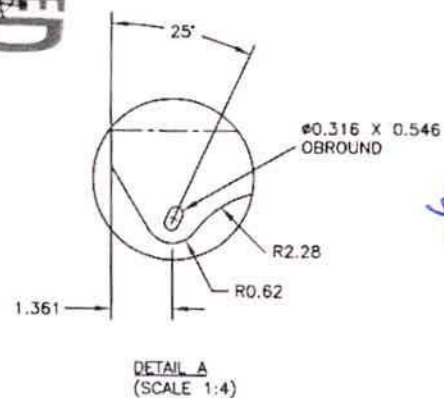
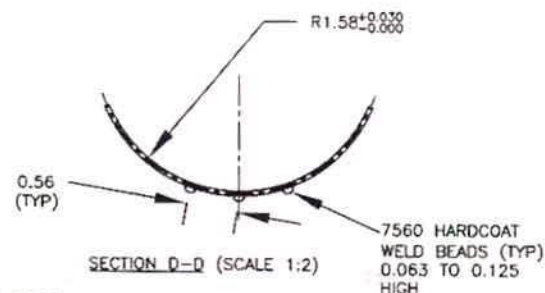
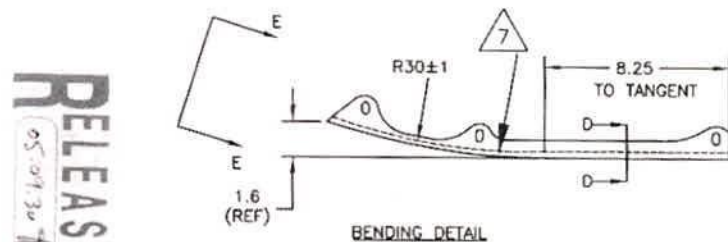
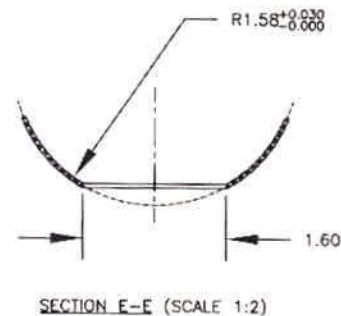
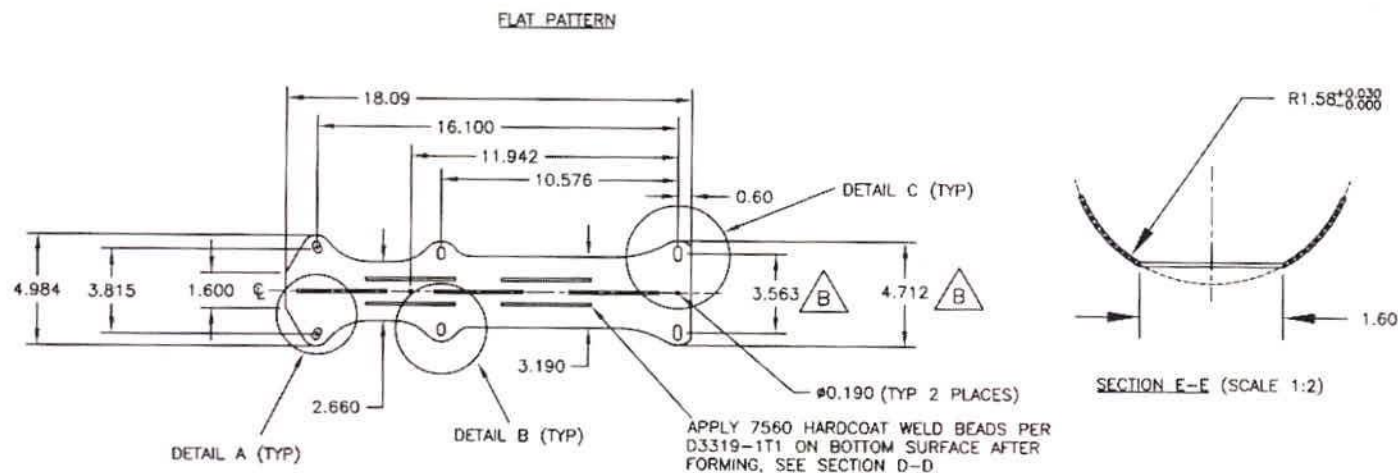
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

**DART**



**D3319-1 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
P11	04	HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1:8
A	NEW ISSUE	REV. B
05.06.06		
B	WIDEN HOLES, REDUCE WIDTH -3/-5/-7	SHEET 1 OF 5

RELEASED  
05.07.30



